

Work Order ID 113789

February-24-14 10:03:40 AM

SPLIT

for Blue Skids

113789

Page 1

Item ID: D3537-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearpad

(6)

Start Date: 2/24/14

Start Qty: 20.00

20

Cust Item ID:

Required Date: 2/24/14

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: MUS

Date: 14-02-26

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

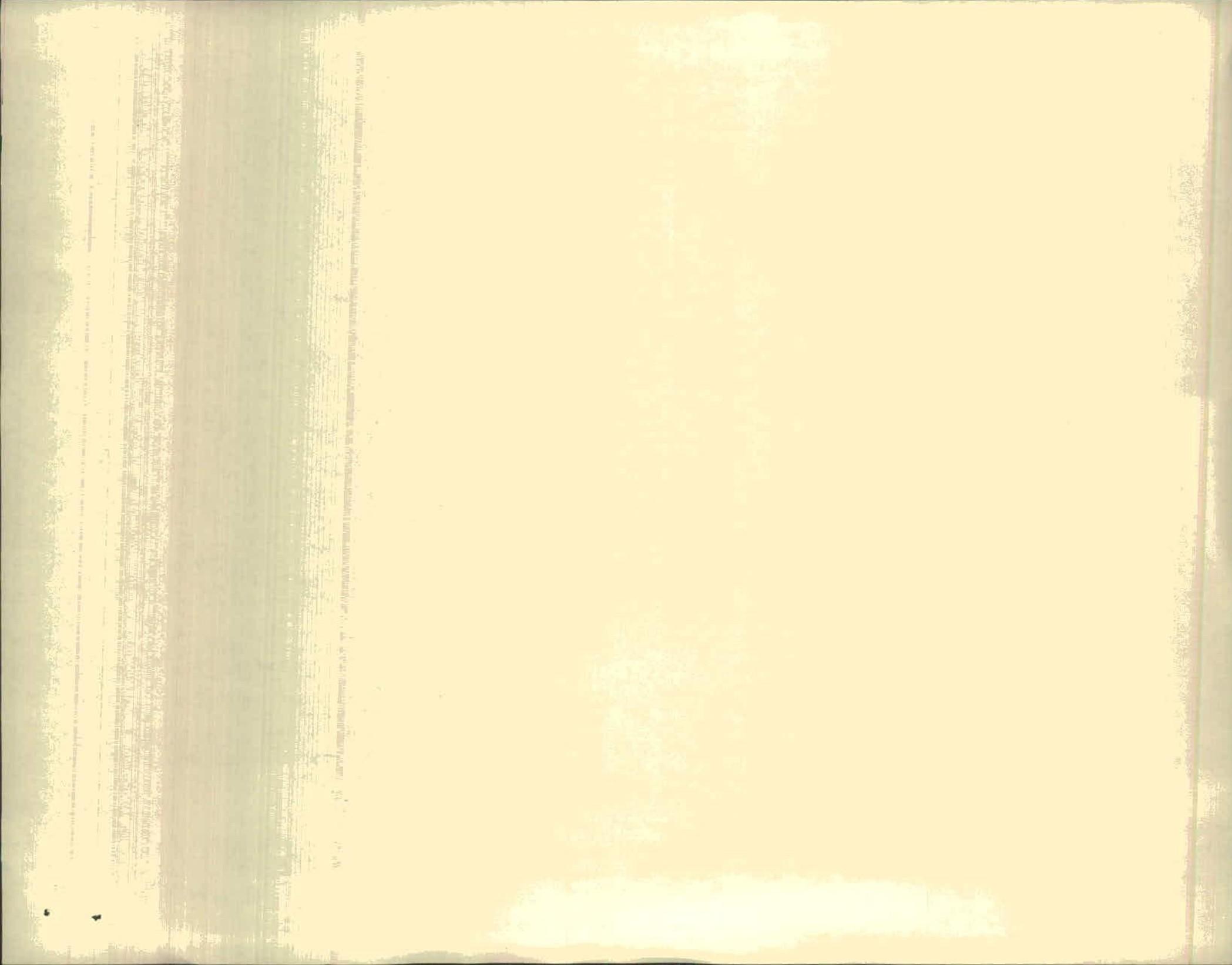
NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00							
100	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	I-Cut as per Dwg D3537 Dwg Rev: ✓ Prog Rev: ✓ 2 Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110	Memo	0.00							
QC									
Quality Control									
120	QCS- Inspect parts - second check	0.00							
120	Memo	0.00							
QC									
Quality Control									
									DAS 9 9.89

21
22 14-3-13

21
22 14-3-13

21 14-08-14



Work Order ID 113789

February-24-14 10:03:40 AM

113789

Page 2

Item ID: D3537-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Wearpad

Stop

NS2

Start Date: 2/24/14 Start Qty: 20.00

20

Cust Item ID:

Required Date: 2/24/14 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID
130

130

Brake NC

Brake NC

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept

Reject

Reject

Insp.
Stamp

0.00

DAS

30

9-89

21

14/03/14

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

0.00

cab

*21

150

150

Large Fab

Large Fab

Large Fab

0.00

Memo

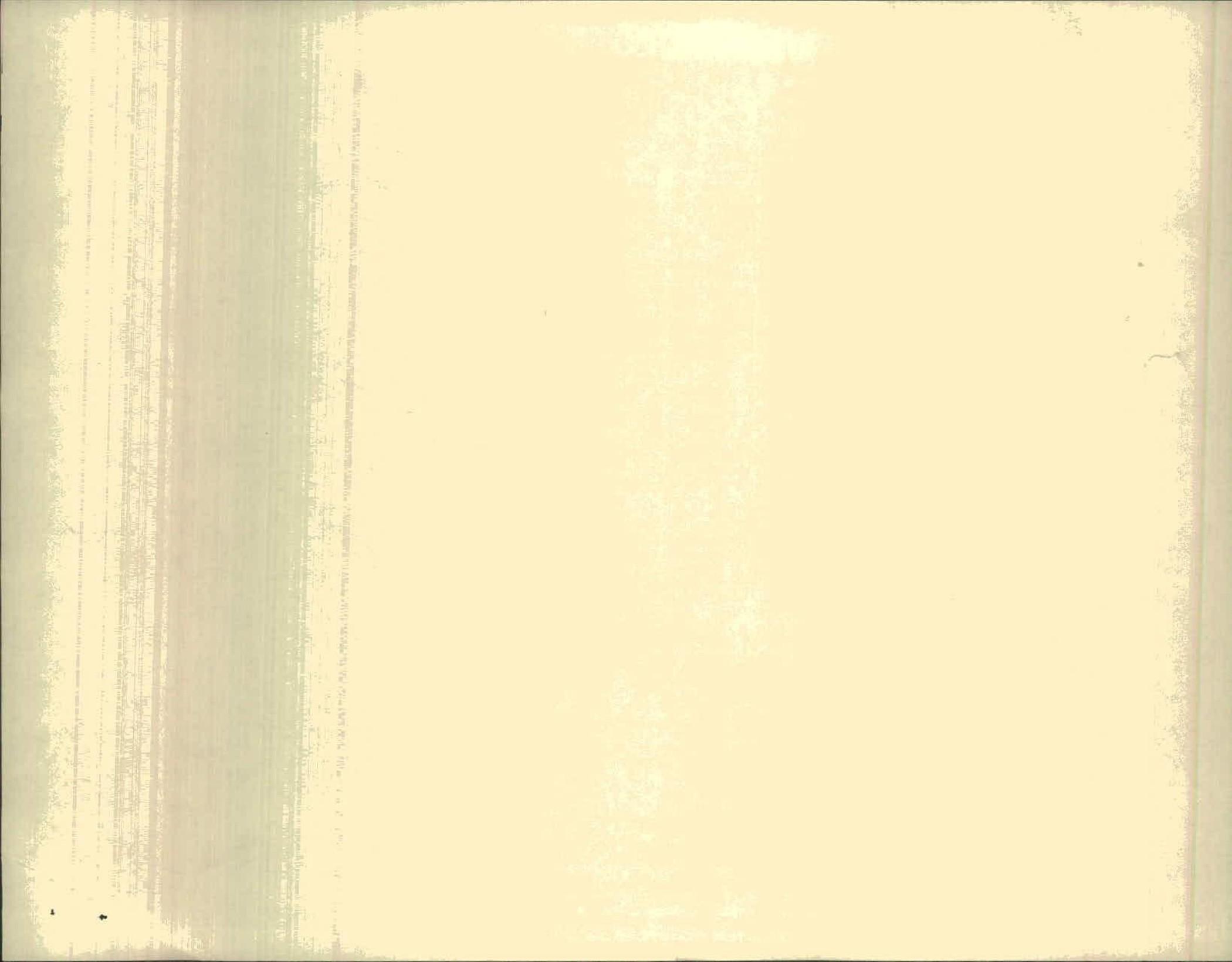
0.00

Qty Description Batch A/R 2059B Hardcoat
~~Weld hardcoat as per Dwg D3437~~

M/27456

x6

14-03-17 MAL



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113789

Page 3

Item ID: D3537-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Wearpad

Stop

NS2

Start Date: 2/24/14

Start Qty: 20.00

20

Cust Item ID:

Required Date: 2/24/14

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

160

160

QC

Quality Control

Operation
Description

QC10- Inspect visual per QSI004- ground welds

Set Up/
Run Hours

0.00

DAS
24
8-89

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

14-3-17

6*

170

170

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

DAS
24
8-89

14-3-17

6*

180

180

Powdercoat

Powder Coating

Grey Sandtex(Ref 4,3,5,6) per QSI005 4.3

0.00

Memo

0.00

START TIME:

11:50

OVEN TEMPERATURE:

350

FINISH TIME:

11:20

6 φ 14-3-17

DAS
34
8-89

Work Order ID 113789

February-24-14 10:03:40 AM

113789

Page 4

Item ID: D3537-3

Revision ID:

Item Name: Wearpad

Start Date: 2/24/14

Start Qty: 20.00

Accept

N900040100

Setup Start

NS1

Required Date: 2/24/14

Req'd Qty: 20.00

20

20

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date: Tooling:

Date: Run

Start *NR1*

QC:

Date: SPC (Y/N):

Date: Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00

190

QC

Quality Control

6 ⑧ 14/03/17

200

Identify as per dwg & Stock Location: EP001

0.00

200

Packaging

Packaging

6 ⑧ 14/03/17

210

QC21- Final Inspection - Work Order Release

0.00

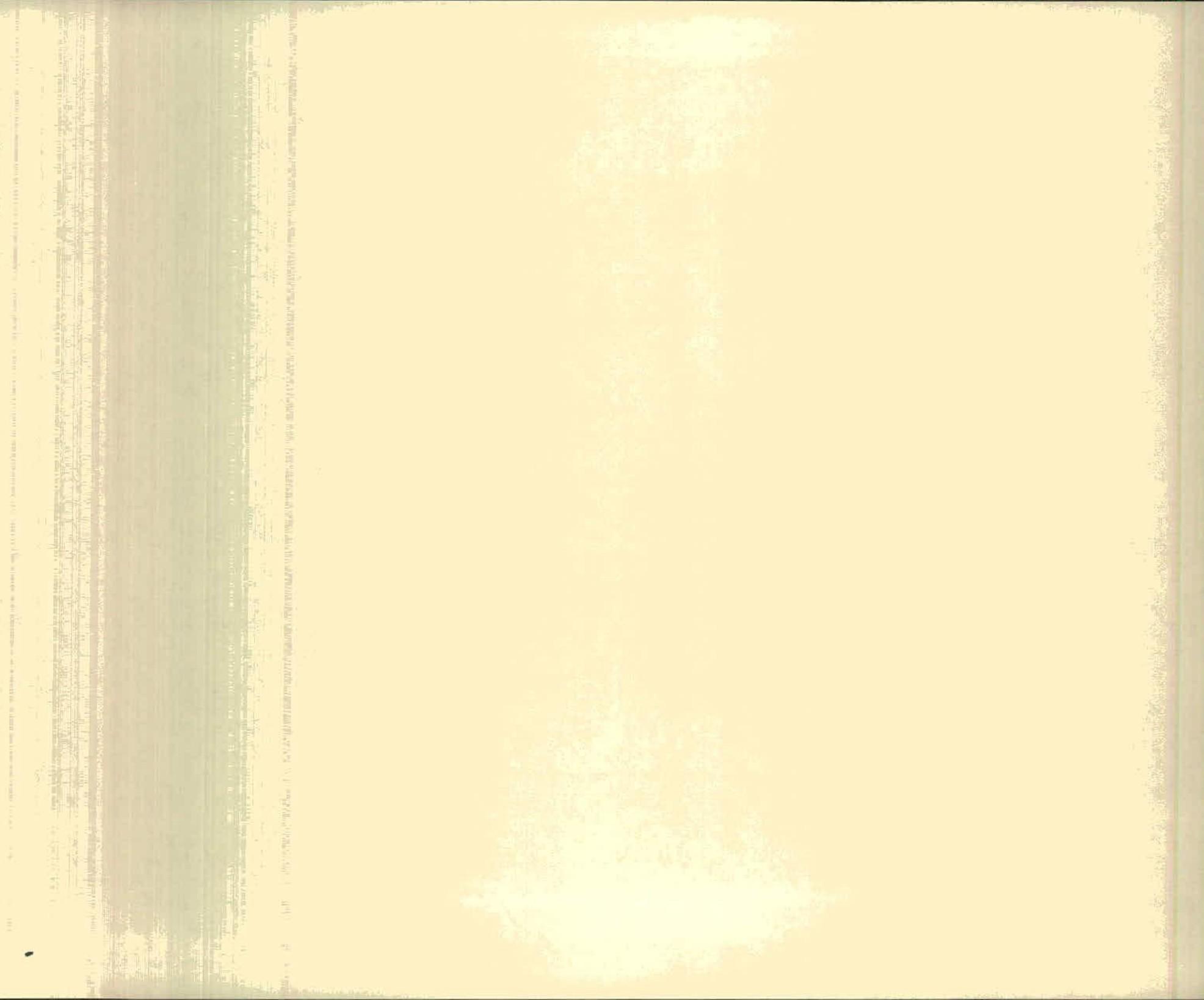
210

QC

Quality Control

14/03/18

NMF
14-3-18



Picklist Print

February-24-14 10:03:40 AM

Page 1

Work Order ID: 113789

113789

Parent Item: D3537-3

D3537-3

Parent Item Name: Wearpad

Start Date: 2/24/14

Required Date: 2/24/14

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	217.1370	0.149	4	**	2/24/14	

M304S16GA

304/31@ Sheet .063

Location	Loc Qty	Loc Code
MAT020	217.137	
M126915	1.487	
M127821	129.33	
M128054	86.32	4.16



DART AEROSPACE LTD	Work Order:	113789
Description: Wearpad	Part Number:	D3537-3
Inspection Dwg: D3537 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

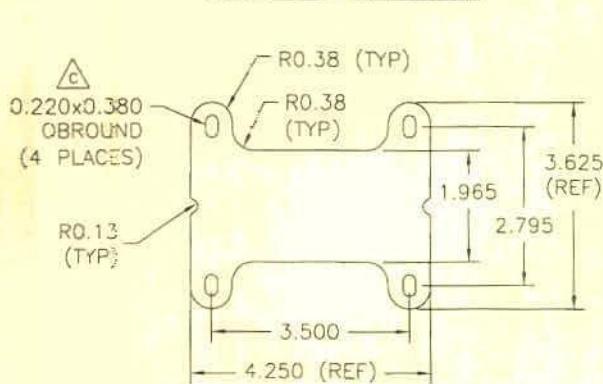
DMS

Measured by:	<i>EL</i>	Audited by:	9 9.89	Prototype Approval:	N/A
Date:	14.03.13.	Date:	14.03.14	Date:	N/A

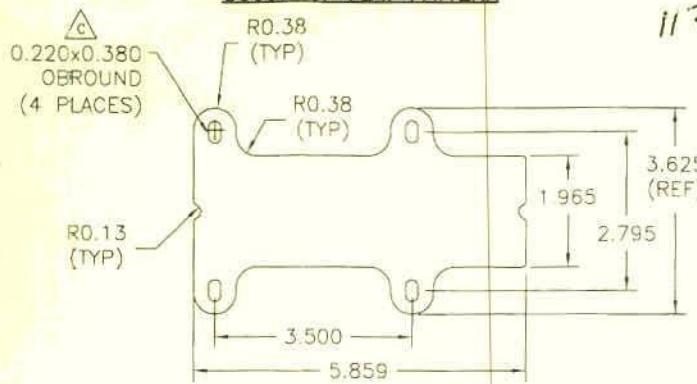
Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM <i>[Signature]</i>	E



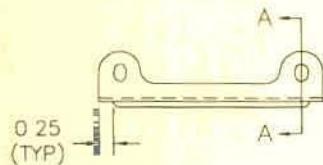
D3537-1F FLAT PATTERN



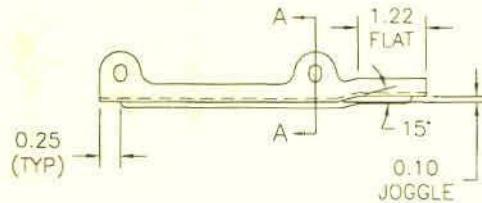
D3537-3F FLAT PATTERN



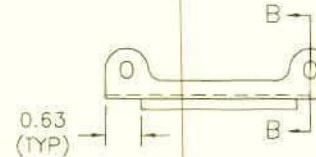
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



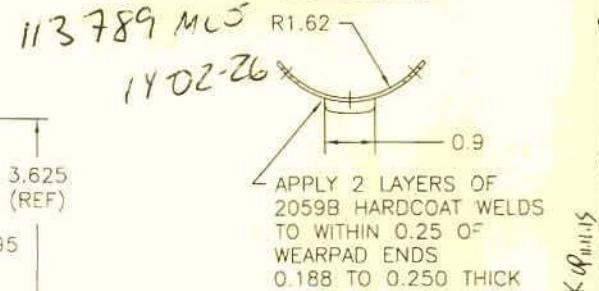
D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16CA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

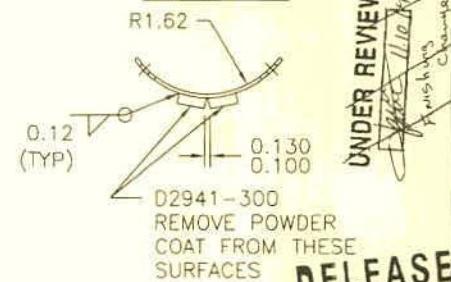
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DART AEROSPACE USA, INC.

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C	CB	PORT HADLOCK, WA
B	PH	
A		
DATE	07.04.13	REV. C
APPROVED		SHEET 1 OF 1
CHECKED		1
DRAWING NO.	D3537	
DATE	07.04.13	SCALE
TITLE	WEARPAD	1:2

SECTION A-A



SECTION B-B



RELEASED
07.05.08 AF
PER ECN 962

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)

